

Work Order ID 163560

Wednesday, June 28, 2017 3:39:00 PM



163560

Page 1

Item ID: D4941-2L08 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Floor Protector, Fwd RH, (Clear)
Start Date: 7/5/2017 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 7/12/2017 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan:  Date: JUN 28 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4941	D								
110	THERMOFORMING MACHINE	0.00							
110									
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: 37041								
	SUPPLIER: PLASTECH								
	MANUFACTURE D4941-2L08 AS PER DWG								
	C OF C IS REQUIRED								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140	HAND FINISHING THERMOFORMING								
Packaging	Memo	0.00							
Packaging									

DAS
13
9-89

17/07/03

5x SP A-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval					
Description Work Order Deviation				Disposition				Completed By				
								Lead hand / Supervisor Approval Verification				
												QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY										
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐						

Picklist Print

Wednesday, June 28, 2017 3:39:00 PM

Page 1

Work Order ID: 163560

163560

Parent Item: D4941-2L08

D4941-2L 08

Parent Item Name: Floor Protector, Fwd RH, (Clear)

Start Date: 7/5/2017

Required Date: 7/12/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev A New Issue 13/12/16 DL
 Revised dimensions 14/02/12 DL
 14/07/02 DL
 IPP Rev. B
 IPP Rev C Revised Dwg.
 IPP Rev D Revised Dwg. 14/07/25 DL
 IPP Rev.E 17.06.13 Now outside process DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-2L08P		Purchased	No			110	Each	0.0000	1	5			
D4941-2L 08P									**				
Floor Protector, Fwd RH, (Clear)													
MLEXS.118-90318-08		Purchased	No			110	sf	194.5690	4.875	24.375			
MI FXS 118-90318-08									**				
Lexan Sheet (Clear)													

5x 8p 17-9-12.

SEP 21 2017

Location

Loc Qty

Loc Code

RM

194.56897

m126994

194.56897

M138294

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

SHOP COPY

RETURN TO

ENGINEERING

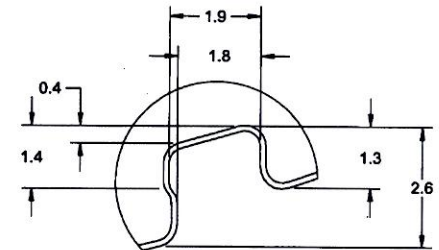
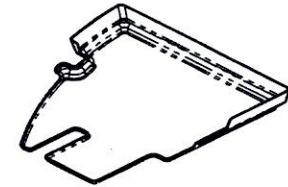
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

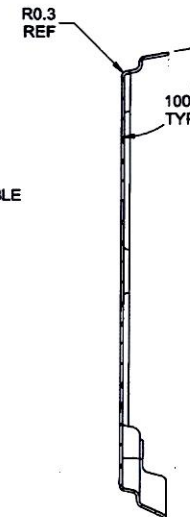
WITH NOTICE

W/OUT NOTICE

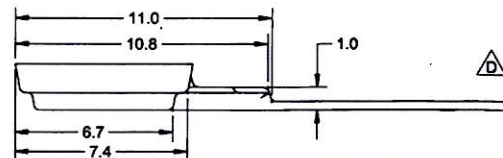
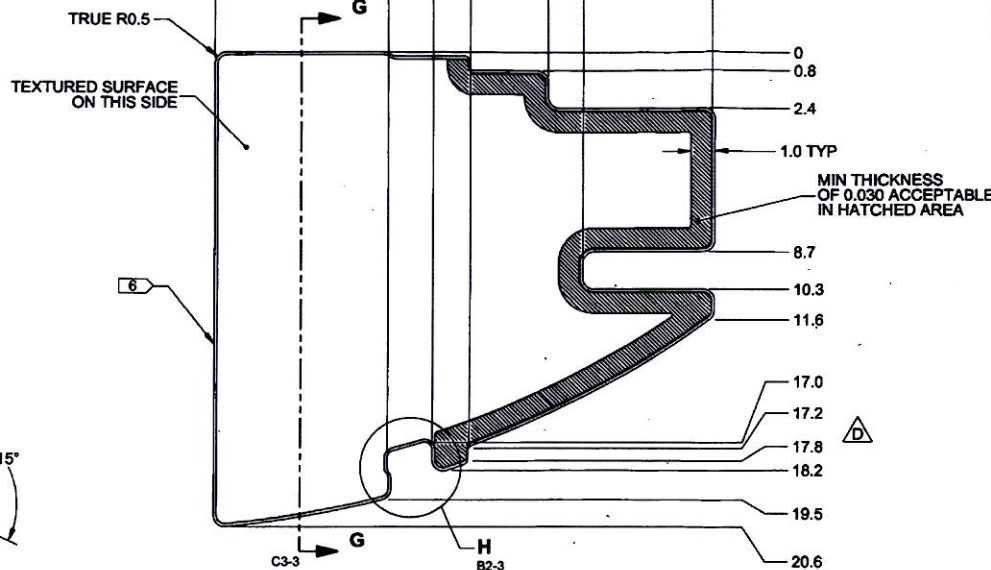
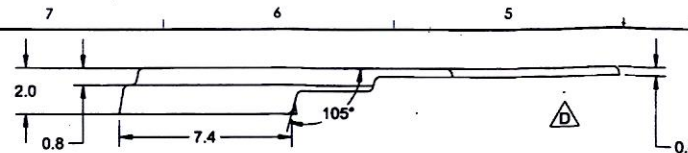
NO. JUN 28 2017



DETAIL H
B8-3



SECTION G-G
C6-3



D4941-2LXX FWD RH FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4
- 7) WEIGHT: 1.5 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9991
- 9) TRIM PER MOLD LEAVING FINISHED EDGES
- 10) MINIMUM THICKNESS AFTER FORMING IS 0.070"

PART NUMBER	DESCRIPTION
D4941-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

APPROVED

DESIGN	AK
DRAWN	AK
CHECKED	VS
MFG. APPR.	DL
APPROVED	HS
DE APPR.	DS
DATE	14.07.25

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4941	REV. D
TITLE CABIN FLOOR PROTECTORS	SHEET 3 OF 5
DATE 14.07.25	SCALE NTS

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RELEASED
2014-10-08
WNP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37041

Purchase Order Date 7/13/2017

PO Print Date 7/14/2017

Page Number 1 of 3

Order From :

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUL 17 2017

Contact Name

Vendor Phone 416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4941-1L08P As per dwg D4941 REV. D B163561	Floor Protector, Fwd LH, (Clear)	8/3/2017 Yes 8/3/2017	5.00 Each	\$105.00	\$525.00
Line Total:						\$525.00
2	D4941-2L08P As per dwg D4941 REV. D B163560	Floor Protector, Fwd RH, (Clear)	8/3/2017 Yes 8/3/2017	5.00 Each	\$105.00	\$525.00
Line Total:						\$525.00

Note:

7/14/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P: 416 736 0004
F: 416 736 0010

Shipment Number: 24292
Shipment Date: 09/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order

37041

Carrier Account #

Sales Order

SO-019295

Incoterms

EX WORKS

Payment Method

PPD/CHG

Tracking Number

Ship Via

FREIGHTCOM INC. -

Item Number - Revision Description

D4941-1L08 - Rev.: D CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-2L08 - Rev.: D CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-3L08 - Rev.: D CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D4941-4L08 - Rev.: D CABIN FLOOR PROTECTORS

HS Code: 3920.61.1000 - OTHER Country of Origin : CA

Quantity UOM
Shipped

5 EA

5 EA

5 EA

5 EA

SPA-9-12

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37041 SO # 019295

Part #	D4941-1L08	Qty.	5	Batch #	-001
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-2L08	Qty.	5	Batch #	-002
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-3L08	Qty.	5	Batch #	-003
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-4L08	Qty.	5	Batch #	-004
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT. 7, 2017 COFC# 011
(Approved QA Signatory)

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Measured by:	DAS 07 9-89	Date:	12/09/14
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[illegible]

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	

PLAS-TECH
Think Plastics™

✕ First Off

Rev.	Date	Change	Revised by	Approved